

Need this wk

# Work Order ID 57256

March 31, 2010 10:34:06 AM



Page 1

Item ID:	D3537-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearpad			Stop		
Start Date:	31/03/2010	Start Qty:	20.00			
Required Date:	09/04/2010	Req'd Qty:	20.00			
Reference:						

Approvals:	Process Plan:		Date:	10-3-31	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:		Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100	FLOW WATER JET	0.00							
	Waterjet								
	FLOW CNC Waterjet								
	304 .063								
	Memo	0.00							
	1-Cut as per Dwg D3537 □ Dwg Rev: <input checked="" type="checkbox"/> □ Prog Rev: <input checked="" type="checkbox"/> □ 2-Deburr if necessary								

B10-4-7

36

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Quality Control								
	Memo	0.00							

B10-4-7

120	QC8- Inspect parts - second check	0.00							
	QC								
	Quality Control								
	Memo	0.00							

Sobuluz

can'to  
x36

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57256

March 31, 2010 10:34:06 AM



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Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 31/03/2010 Start Qty: 20.00

Required Date: 09/04/2010 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-Identify as D3537-1								
140 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch □ A/R 2059B Hardcoat □1-Weld as per Dwg D3537 using Jig DT 8210 □2-Remove any weld that penetrated through Wearpad if necessary M114373								
150 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									

SB 10/6/12

36

EL 10-5-12 X38

counted  
436

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57256

March 31, 2010 10:34:06 AM



Page 3

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 31/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Scalor 12

count  
X36

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:15AM  
FINISH TIME: 7:45AM

OVEN TEMPERATURE:  
320°C

7:15AM 10/05/13

X36 6

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

360 BR 10-5-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57256**

March 31, 2010 10:34:06 AM



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Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 31/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: FP-17

0.00

el 10/05/13

Packaging

Memo

0.00

X36 Ø

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/13 MFMF  
10-5-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

March 31, 2010 10:34:12 AM

Page 1

Work Order ID: 57256



Parent Item: D3537-1



Parent Item Name: Wearpad


Start Date: 31/03/2010

Required Date: 09/04/2010

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	138.6899	2.2316			



B10-4-7

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT20

138.6898737

106860

8.0295

111924

25.1689737

112442

29.8865

113295

75.6049

113298

36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	57256
<b>Description:</b> Wearpad		<b>Part Number:</b>	D3537-1
<b>Inspection Dwg:</b> D3537	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.251	X			
3.500	+/-0.010	3.497	X			
1.965	+/-0.010	1.969	X			
2.795	+/-0.010	2.795	2			
3.625	+/-0.010	3.622	X			
0.220 x 0.380	+/-0.010	0.220 x 0.380	X			

<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-4-7	<b>Date:</b> 10/04/07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

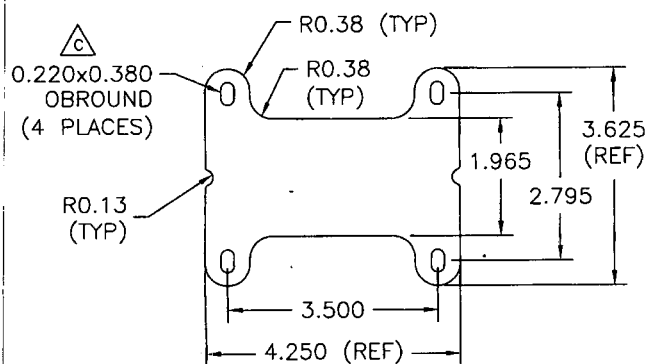
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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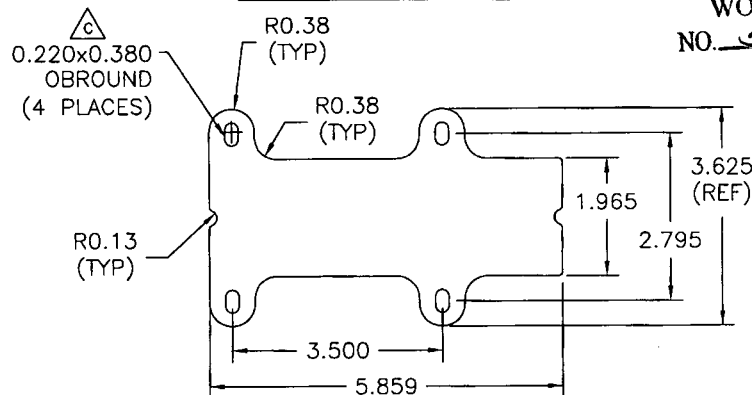
**NOTE:** Date & initial all entries

SI.  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57259  
*P/10-3-31*

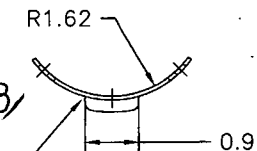
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

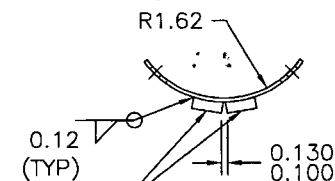


### SECTION A-A



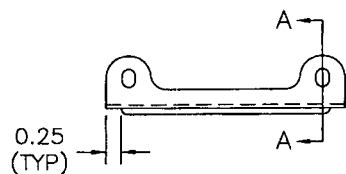
APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

### SECTION B-B

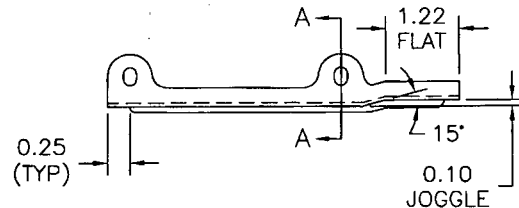


D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

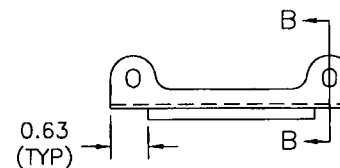
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



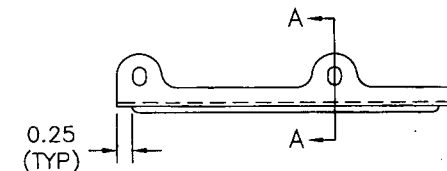
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

RELEASED  
07.05.08 PH  
PER ELN  
962

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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